

78524

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Draw Nbr	Revision Nbr
D3006	Rev A

0.00

100

Waterjet

FLOW CNC Waterjet

1010 . 063

Memo

1-Cut as per Dwg D3006

Dwg Rev: 1
Prog Rev: 1

2-Deburr if necessary

0.00

B12-1-13

②

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

B12-4-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78524

January-10-12 2:43:40 PM

78524

Page 2

Item ID: D3006-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 10/01/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 24/01/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
140 *140* Large Fab Large Fab	Large Fab Memo Weld 7560 hardcoat & D3009 cup-as per dwg D3005 & QSI 004 A/R S.S. Rod Batch: <u>M9326</u> A/R Hard facing Rod Batch: <u>M117961</u>	0.00 0.00							
150 *150* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							

S 12/6/15

(+2)

Q 127-17 (X2)

2 0 DE12-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78524

78524

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January-10-12 2:43:40 PM

Item ID: D3006-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 10/01/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 24/01/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

170 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00

170 Powdercoat 0.00

Powder Coating

Memo
 START TIME: 9:20
 OVEN TEMPERATURE: 320 OF
 FINISH TIME: 9:50

175 QC3- Inspect Part Finish 0.00

175 QC 0.00

Quality Control

2X0 M/L 12/01/19

20 H 12/01/19
 COUNTED

M 115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78524***78524***

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Item ID: D3006-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 10/01/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 24/01/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: 25b

0.00

180

Packaging

Memo

0.00

Packaging

12/1/19 2

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/1/20 2MLJ 12/01/20
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 78524

78524

Parent Item: D3006-041

D3006-041

Parent Item Name: Wearplate

Start Date: 10/01/2012

Required Date: 24/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A01.04.04New IssueECIPP RevB: now made on waterjet DD
10.02.12 verified by:JLM IPP Rev:C add qc3 DD 10.02.19 Verified
By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S16GA

Purchased

No

100

sf

86.0000

1.0417

2.193053

M1010S16GA

1010/1025 sheet 16GA

**

B12-1-13

Location

Loc Qty

Loc Code

MAT019

86

116791

27.4

117500

26.6

118965

32

116791

(2)

D3009-1

Manufactured

No

140

Each

124.0000

8

16

D3009-1

Cup

**

B12-1-17

Location

Loc Qty

Loc Code

WA030

124

36482

71

37488

53

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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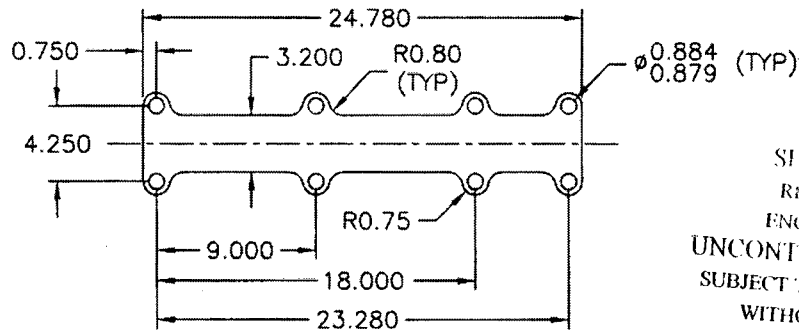
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3006	REV. A SHEET 1 OF 1
DATE 01.03.23	TITLE WEARPLATE		SCALE 1:10
A	01.03.23	NEW ISSUE	

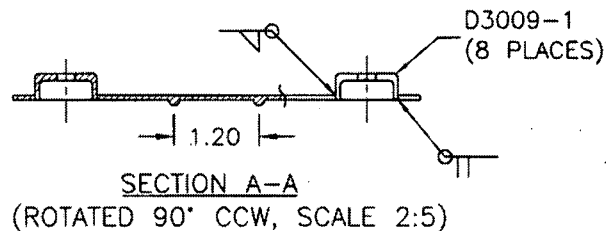
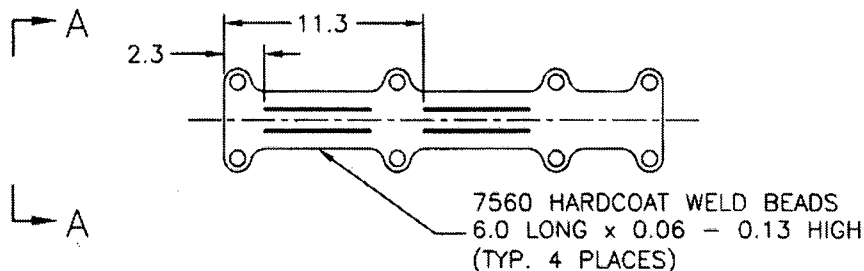
RELEASED
9.04.09

D3006-1 FLAT PATTERN



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78524 H.C.J.
12/01/10

D3006-041 WELDMENT



BREAK ALL SHARP EDGES 0.010 TO 0.020

WELD PER QSI 004

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 SERIES STEEL 16
GAUGE (0.060 THICK)

FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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